

Work Order ID 134653

December 10, 2015 12:48:35 PM

134653

Page 1

Item ID: D2721-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 206B Step Ass'Y

Start Date: 7/14/2015 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 7/14/2015 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: SH 120151210 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2721	Rev C

100		0.00							
100	Large Fab								
Large Fab	Memo	0.06							
Large Fab	Cut D2721-1 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding								

DD 15-12-14

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110	Large Fab								
Large Fab	Memo	0.13							

Large Fab Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT 10215 A+B followed by Jig DT

BB 15-12-17

A/R AL Rod Batch: M132917/M131562

Grind end cap welds flush

DD/BB

15-12-17

65.62

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Item ID: D2721-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206B Step Ass'Y

Start Date: 7/14/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/14/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

(u)

15-12-21

DAS

9

9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(u)

15-12-21

DAS

9

9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.02

Hand Finishing

(4)

15-12-21

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Item ID: D2721-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: 206B Step Ass'Y

Stop ***NS2***

Start Date: 7/14/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/14/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-89
150	QC7-Inspect Chemical Conversion Coat	0.00								
150										
QC	Memo	0.00								
Quality Control										
160		0.00								
160	Large Fab									
Large Fab	Memo	0.06								
Large Fab	Inspect for foreign object per QSI 024									
	Weld Remaining end cap as per Dwg D2721 using Jig DT									
	Jig DT									
	A/R AL Rod Batch: <u>MB1562</u>									
	Grind End Cap Welds Flush									

4 0 15-12-21

4 0 BE 15-12-21

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Item ID: D2721-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206B Step Ass'Y
 Start Date: 7/14/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/14/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.01							
Quality Control									

4X

BAS
27
DEC 22 2015

PP 134653
139870

9X

BAS
27
DEC 22 2015

MLJ

DEC 22 2015

MLJ

DEC 22 2015

Picklist Print

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Work Order ID: 134653

134653

Parent Item: D2721-041

D2721-041

Parent Item Name: 206B Step Ass'y

Start Date: 7/14/2015

Required Date: 7/14/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing
walk DD 10.02.24 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

120.0000

1

4

D2622-120C

Step Extrusion

BE 15-12-14

Location

Loc Qty

Loc Code

WA003

120

130161

5

134783

115

D2734

Manufactured

No

110

Each

72.0000

1

4

D2734

Step End Plate

BE 15-12-14

Location

Loc Qty

Loc Code

WA003

72

133142

20

134415

30

135488

22

D3461-1

Manufactured

No

110

Each

17.0000

1

4

D3461-1

Mounting Plate

BE 15-12-14

Location

Loc Qty

Loc Code

WA003

17

58756

17

Picklist Print

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Work Order ID: 134653

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Parent Item: D2721-041

D2721-041

Parent Item Name: 206B Step Ass'Y

Start Date: 7/14/2015

Required Date: 7/14/2015

Start Qty: 4.00

Required Qty: 4.00

D3461-3 Manufactured No

110 Each 15.0000 1 4

D3461-3

Mounting Plate

**

LocationLoc QtyLoc Code

WA003

15

103990

3

126300

12

110 Each 5.0000 1 4

D3461-5 Manufactured No

D3461-5

Mounting Plate

**

LocationLoc QtyLoc Code

WA003

5

102886

5

110 Each 20.0000 1 4

D3461-7 Manufactured No

D3461-7

Mounting Plate

**

LocationLoc QtyLoc Code

WA003

20

107696

12

127723

8

160 Each 72.0000 1 4

D2734 Manufactured No

D2734

Step End Plate

**

LocationLoc QtyLoc Code

WA003

72

133142

20

134415

30

135488

22

BE151214
+1 B126300BE151215
+1 B102886

BE151215

BE151221

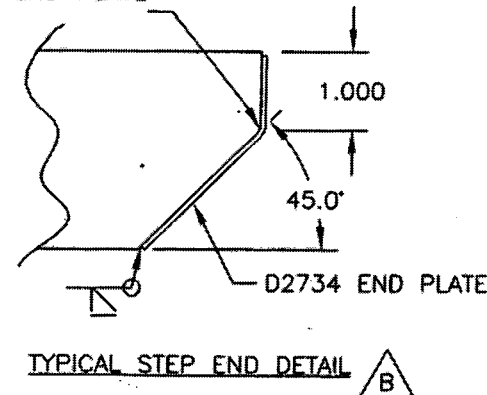
DART

RELEASED
05-11-14



D2721-041/-042 STEP ASSEMBLY

- ALL DIMENSIONS ARE IN INCHES
ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



TYPICAL STEP END DETAIL

DESIGN	DRAWN BY		DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. C
PH	PH			
CHECKED	APPROVED	DRAWING NO.	D2721	SHEET 1 OF 1
PH	PH			
DATE	TITLE		SCALE	
05.09.19	206B STEP ASSEMBLY		NTS	
A	97.12.04	NEW ISSUE ---		
B	98.10.19	79" WAS 80", UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0		
C	05.09.19	RE-DESIGN, ADD D3461-1/-3/-5/-7		

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20151210

SH 13465

DART AEROSPACE LTD

Work Order: 134653

Description: 206 B STEP ASS'Y

Part Number:	D2721-041
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Inspection Dwg: D2221 Rev: C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: BARCLAY ELLIOT

Audited by:

Preliminary Approval:

Date:	15-12-17
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Date: 15-12-17

Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15